

Work Order ID 164300

Monday, July 17, 2017 9:22:40 AM

164300

Page 1

Item ID: D4941-2L08 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Floor Protector, Fwd RH, (Clear)
Start Date: 7/21/2017 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 8/4/2017 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: DAS 21 9-89 Date: JUL 17 2017 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4941	D								
110	THERMOFORMING MACHINE	0.00							DAS 13 9-89
110									
Purchasing	Memo	0.00							
Purchasing	ISSUE P/O: <u>37108</u>								
	SUPPLIER: PLASTECH								
	MANUFACTURE D4941-2L08 AS PER DWG								
	C OF C IS REQUIRED								
140	Receive & Inspect for Damage & Mat'l Certs	0.00							
140	HAND FINISHING THERMOFORMING								
Packaging	Memo	0.00							
Packaging									

4x SP17-9-12

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																																																										
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐																																																																

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Page 2

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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150	QC6- All purchased or subcontracted products	0.00							
150									
QC	Memo	0.00							
Quality Control									

170	Identify as per dwg & Stock Location SH65	0.00							
170									
Packaging	Memo	0.00							
Packaging									

180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

④ 17.09.20 10

4 SEP 20 2017 DAS 6 8-89

17/9/21 JH

SEP 20 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐				
Date :	Step #:	QTY Effective :			MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			Completed By	
					Lead hand / Supervisor Approval Verification	
					QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐				
OTHER : ☐						

Picklist Print

Page 1

Monday, July 17, 2017 9:22:43 AM

Work Order ID: 164300

164300

Parent Item: D4941-2L08

D4941-21 08

Parent Item Name: Floor Protector, Fwd RH, (Clear)

Start Date: 7/21/2017

Required Date: 8/4/2017

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev A New Issue 13/12/16 DL
 Revised dimensions 14/02/12 DL
 14/07/02 DL
 IPP Rev. B
 IPP Rev C Revised Dwg.
 IPP Rev D Revised Dwg. 14/07/25 DL
 IPP Rev.E 17.06.13 Now outside process DP Verify DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4941-2L08P		Purchased	No			110	Each	0.0000	1	4			
D4941-21 08P									**				
Floor Protector, Fwd RH, (Clear)													
MLEXS.118-90318-08		Purchased	No			110	sf	194.5690	4.875	19.5			
MI FXS 118-90318-08									**				
Lexan Sheet (Clear)													

Location

Loc Qty

Loc Code

RM

194.56897

m126994

194.56897

138294.

19.5 sq ft.

DAS
07
9-89

17/07/13

4x 8017-9-12

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER :			
Misidentified ☐	Past Due ☐																																																																

DART AEROSPACE LTD		Work Order: 164300
Description: Floor Protector, RH Fwd		Part Number: D4941-2L02/L08
Inspection Dwg: D4941	Rev: D	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST
THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than "	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: DAS 07 9-89	Date: 17/09/13
---------------------------------------	-----------------------

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.0	+/-0.100	2.1"	✓			
1.0	+/-0.100	1.08"	✓			
0.4	+/-0.100	0.49"	✓			
20.6	+/-0.100	20.6"	✓			
21.3	+/-0.100	21.4"	✓			
0.070	Min	0.099"	✓			
0.030	Min	0.043"	✓			
7.4"	+/-0.100	7.48"	✓			
10.9"	+/-0.100	10.9"	✓			
10.9"	+/-0.100	11.0"	✓			

Measured by: DAS 07 9-89	Date: 17/09/13
Audited by: 90	Date: 17-09-20
Preliminary Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	15.04.27	New Issue	KJ	

DQA: _____ Date: _____



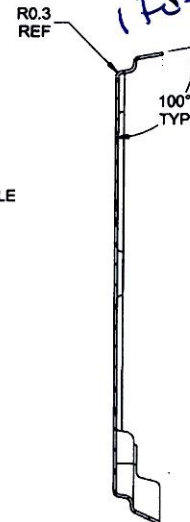
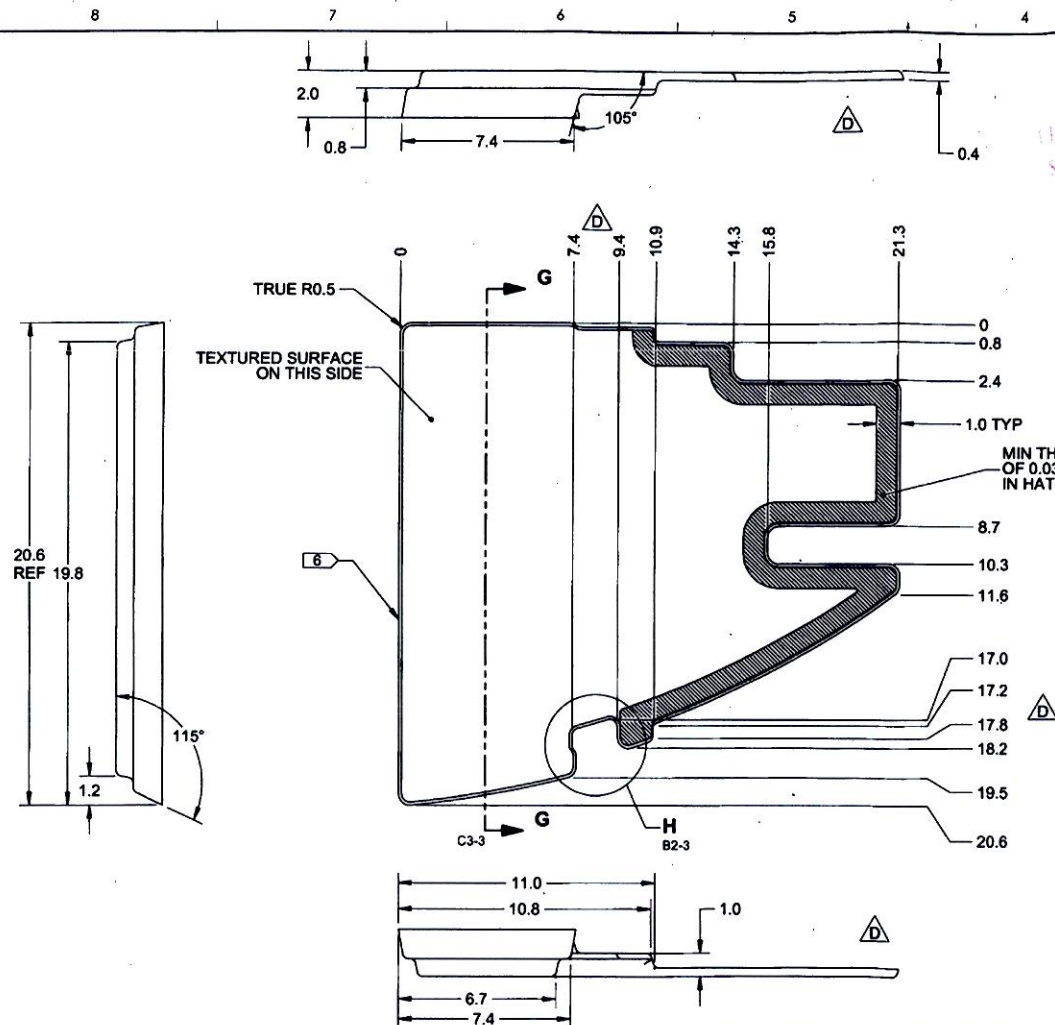
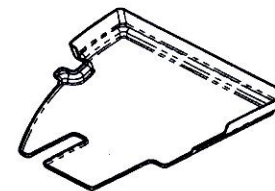
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

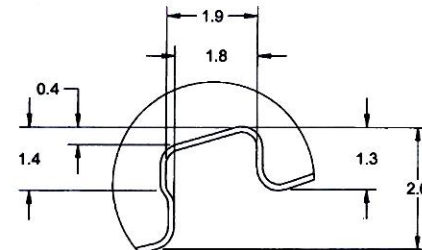
Work Order update only ☐

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Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____									
Misidentified ☐	Past Due ☐										

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 164300 M.L.S
170717



SECTION G-G
C6-3



DETAIL H
B6-3

- NOTES:
1) MATERIAL: SEE TABLE
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY PER DART QSI 044 6.4
7) WEIGHT: 1.5 lbs
8) THERMOFORM PER QSI 022 USING MOLD DT9991 TRIM PER MOLD LEAVING FINISHED EDGES
9) MINIMUM THICKNESS AFTER FORMING IS 0.070"

D4941-2LXX FWD RH FLOOR PROTECTOR

PART NUMBER	DESCRIPTION
D4941-2L02	F6006 SUEDE/POLISHED 701 BLACK LEXAN SHEET 0.125 THICK (REF DART SPEC MLEXS.125-F6006-02)
D4941-2L08	90318 PROTECT-A-GLAZE 112 CLEAR LEXAN SHEET 0.118 THICK (REF DART SPEC MLEXS.118-90318-08)

APPROVED	DESIGN	AK	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	DRAWING NO. D4941	REV. D
	DRAWN	AK			SHEET 3 OF 5
	CHECKED	VS	TITLE CABIN FLOOR PROTECTORS	SCALE	
	MFG. APPR.	DL		NTS	
	APPROVED	HS			
	DE APPR.	DS			
	DATE	14.07.25	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		

RELEASED
2014-10-08



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO37108**

Purchase Order Date 7/19/2017

PO Print Date 7/19/2017

Page Number 8 of 9

Order From :

PLAS-TECH
115 APPLEWOOD CRESCENT
CONCORD, ONTARIO L4K 5C1

VC-PLT01

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 416-736-0004

Ship To Contact

Ship To Phone

Ship Via:

Ship Acct:

Buyer

Customer POID

Customer Tax #

Terms

Currency

FOB

Chantal Lavoie

10127-2607

Net 30

CAD

Destination-Collect

Line Total: \$400.00

22 D4941-2L08

Floor Protector, Fwd RH,
(Clear)

7/31/2017

Yes

7/31/2017

4.00

Each

\$100.00

\$400.00

MANUFACTURE AS PER DWG D4941 REV. D
B164300

PD 1709.20

SP 17-9-12

Line Total: \$400.00

23 D4941-3L08P

Floor Protector, Aft LH,
(Clear)

7/31/2017

Yes

7/31/2017

4.00

Each

\$100.00

\$400.00

MANUFACTURE AS PER DWG D4941 REV. D
B164302

Line Total: \$400.00

24 D4941-4L08P

Floor Protector, Aft RH,
(Clear)

7/31/2017

Yes

7/31/2017

4.00

Each

\$100.00

\$400.00

MANUFACTURE AS PER DWG D4941 REV. D
B164304

Note:

7/19/2017



115 Applewood Crescent
Concord, ON, L4K 5C1
PLASTECHONLINE.COM
P- 416 736 0004
F- 416 736 0010

Packing Slip

Shipment Number: 24293
Shipment Date: 08/08/2017
BOL Number:
Customer Key: C1887
Salesperson: MIKE AUBE
Page Number: 1 of 1

B DART AEROSPACE LTD.
I 1270 ABERDEEN STREET
L HAWKESBURY ON K6A 1K7
L CA
T Attn: ROBERT ABOUD
O Buyer Contact: ROBERT ABOUD

S DART AEROSPACE
H 1270 ABERDEEN STREET
I HAWKESBURY ON K6A 1K7
P CA
T Attn: ROBERT ABOUD
O

Purchase Order
37108
Carrier Account #

Sales Order
SO-019288

Ship Via
FREIGHTCOM INC. -

Incoterms
EX WORKS

Payment Method
PPD/CHG
Tracking Number

Item Number - Revision	Description	Quantity Shipped	UOM
D4941-1L08 - Rev.: D	CABIN FLOOR PROTECTORS HS Code: 3920.61.1000 - OTHER Country of Origin : CA	4	EA
D4941-2L08 - Rev.: D	CABIN FLOOR PROTECTORS HS Code: 3920.61.1000 - OTHER Country of Origin : CA	4	EA
D4941-3L08 - Rev.: D	CABIN FLOOR PROTECTORS HS Code: 3920.61.1000 - OTHER Country of Origin : CA	4	EA
D4941-4L08 - Rev.: D	CABIN FLOOR PROTECTORS HS Code: 3920.61.1000 - OTHER Country of Origin : CA	4	EA

SP79-12.

Number of Containers

Gross Weight

Shipped By

Certificate Of Conformance

Customer: DART AEROSPACE LTD P.O. # 37108 SO # 019288

Part #	D4941-1L08	Qty.	4	Batch #	-021
Description	CABIN FLOOR PROTECTORS 1 SHEET M138294				
Part #	D4941-2L08	Qty.	4	Batch #	-022
Description	CABIN FLOOR PROTECTORS 1 SHEET M138294				
Part #	D4941-3L08	Qty.	4	Batch #	-023
Description	CABIN FLOOR PROTECTORS 1 SHEET M138294				
Part #	D4941-4L08	Qty.	4	Batch #	-024
Description	CABIN FLOOR PROTECTORS 1 SHEET M138294				
Part #		Qty.		Batch #	
Description					
Part #		Qty.		Batch #	
Description					
Part #		Qty.		Batch #	
Description					
Part #		Qty.		Batch #	
Description					

Note: All parts are not identified as meeting QSI044.

By: BRUCE QUAN Date: SEPT 7, 2017 COFC# 010
(Approved QA Signatory)

Page: 1 of 1



PLAS-TECH
Think Plastics™

Rev.	Date	Change	Revised by	Approved